

Injection Moulding Processing Guide for Perflex TPE LP series

Processing Temperature

Temperatures	VALUE(Metic)
1st Zone-Rear	175-180 °C
2nd Zone-Center	185-190 °C
3rd Zone-Front	190-205 °C
4th Zone-Nozzle	180-190 °C
Mold Temperature	30-40 °C

Pressure, Velocity, Recovery, Timers

Pressure	VALUE(Metic)
1st Stage-Boost	45-800 kg/ cm ²
2nd Stage-Hold	15-40 % of Boost
Back Pressure	5-10 kg/ cm ²

Velocity

Injection Velocity	Fast 30-80 mm/sec
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Recovery

Screw Speed	75-125 RPM
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Timers

Hold Time(Thick part)	4-10 sec
Hold Time(Thin part)	1-3 sec

Drying

Drying Temperature	50-60°C
Drying Time	1-2 hrs

Purging

Purge thoroughly before and after use of this product with a low flow (0.5-3 MFR) polypropylene(PP) or polyethylene(PE)

Coloring

Color concentrates with polypropylene (PP), ethylene Vinyl acetate (EVA), or low density polyethylene (LDPE) Carries are most suitable for coloring, concentrates based on PVC should not be used. The final determination of color concentrate be determined by the customer.

Regrind

Regrind levels up to 20% can be used with minimal property loss, provided that the regrind is free of contamination.

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